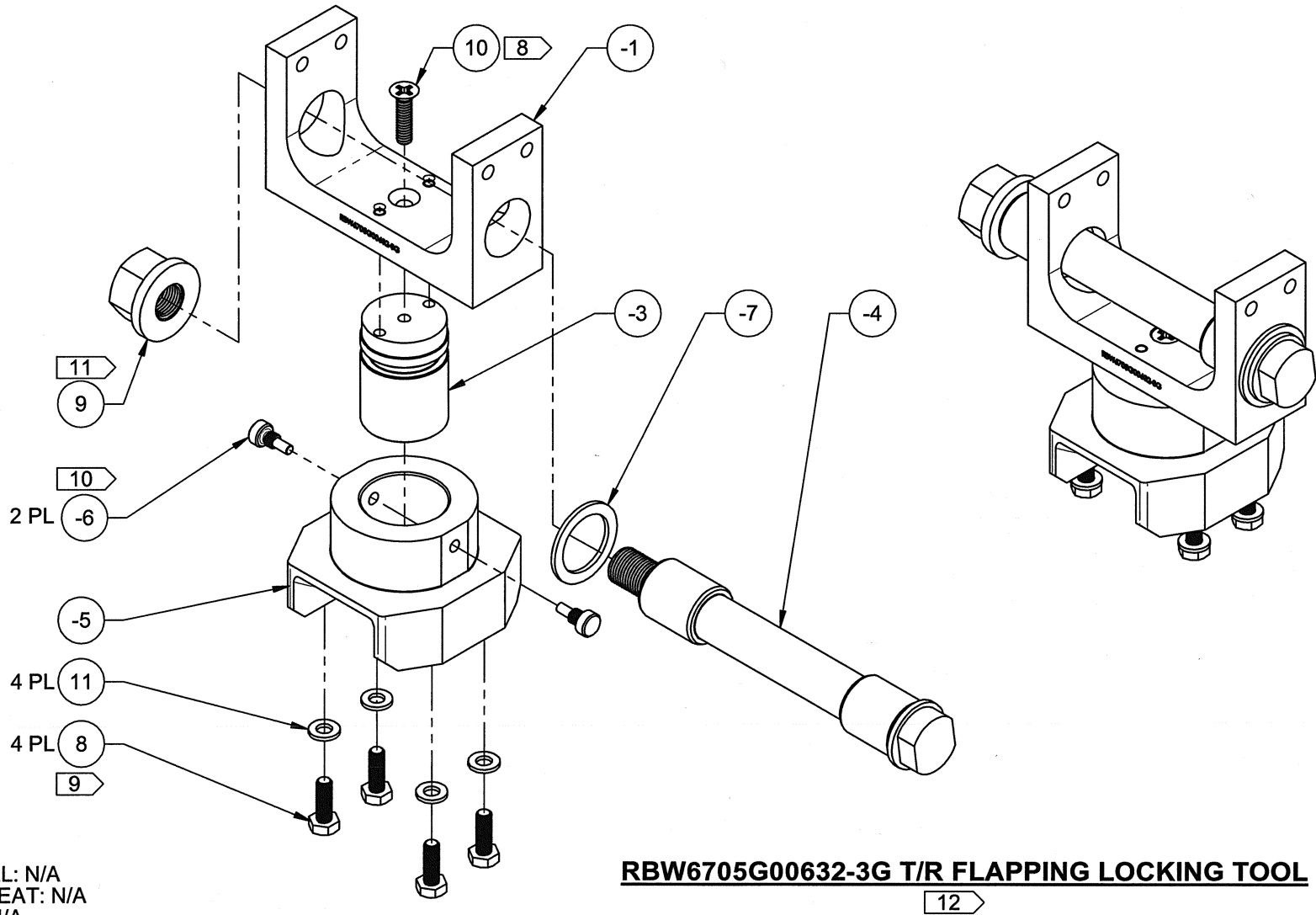


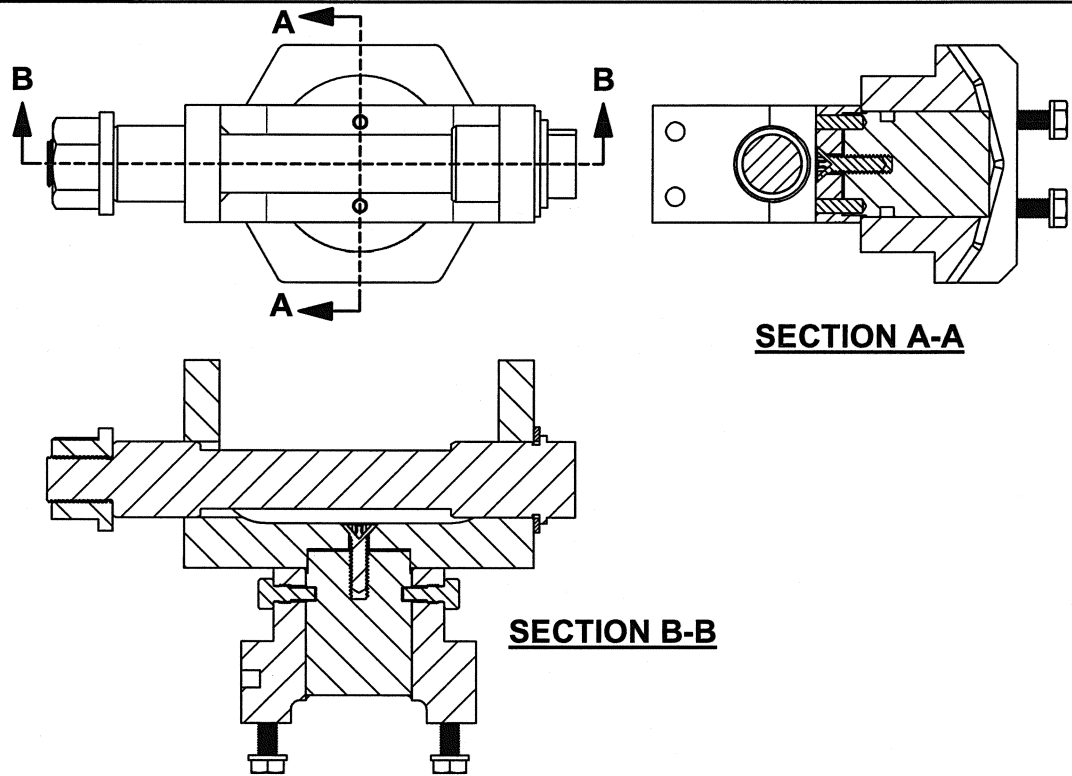
ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6705G00632-3G-1	YORK ASSY
-3	1	RBW6705G00632-3G-3	BASE
-4	1	RBW6705G00632-3G-4	BOLT
-5	1	RBW6705G00632-3G-5	BASE
-6	2	RBW6705G00632-3G-6	KNOB
-7	1	RBW6705G00632-3G-7	WASHER
8	4	McMaster#92620A563 OR EQUIV	ZINC YELLOW-CHROMATE PLATED HEX HEAD SCREW GRADE 8 STEEL 1/4"-28 x 3/4" LG.
9	1	McMaster#91030A445 OR EQUIV	LOW-STRENGTH STEEL FLANGE NUT BLACK OXIDE 5/8"-18
10	1	McMaster#90273A542 OR EQUIV	STEEL ZINC PLATED PHILLIPS FLAT HEAD SCREW 82° COUNTERSINK ANGLE 1/4"-20 x 1" LG.
11	4	NAS1149F0463P	STEEL WASHER 0.265" ID. X 0.500" OD. X 0.063" THK.



**RBW6705G00632-3G T/R FLAPPING LOCKING TOOL**

**NOTES:**

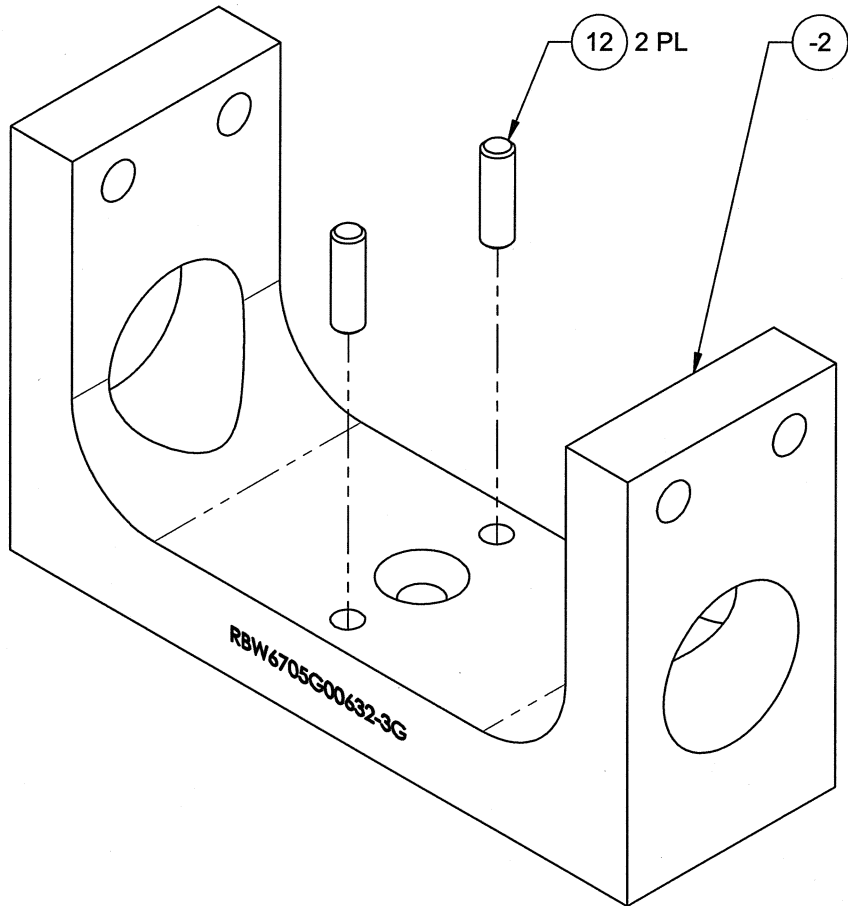
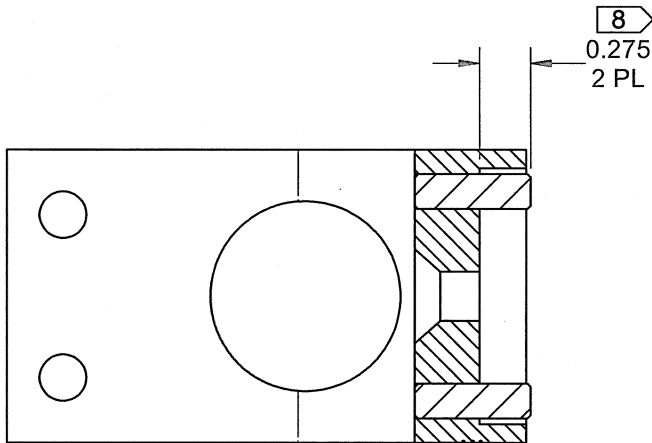
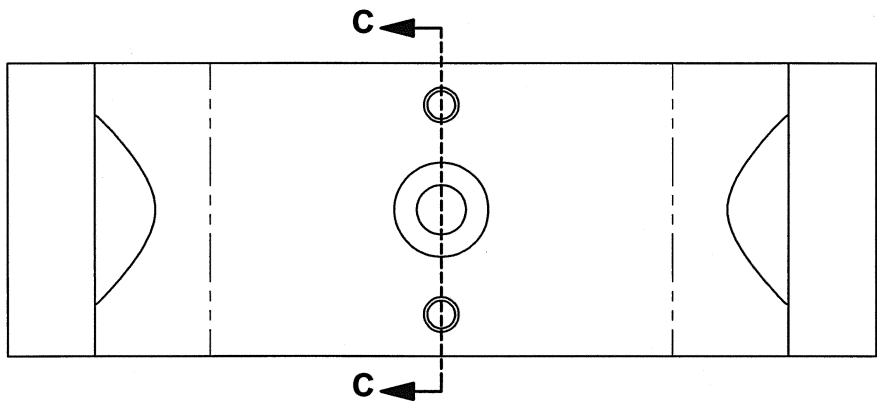
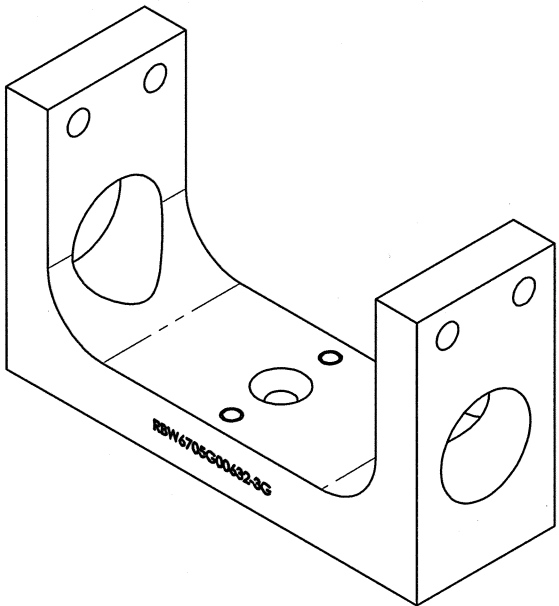
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 10 THEN ASSEMBLE HAND TIGHT WITH ITEMS -1 & -3 AND REMOVE EXCESS
- 9) INSTALL ITEM 8 HAND TIGHT
- 10) INSTALL ITEM -6 WITH ITEM -5 HAND TIGHT ONTO ITEM -3
- 11) INSTALL ITEM 9 HAND TIGHT WITH ITEM -4
- 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



SEE OLDER PDF FOR MORE INFO, TEMPLATE UPDATED PER DART HBY STANDARDS,  
ITEM -1 CHANGED FOR ITEM -2,  
ASSY -1 ADDED, IS YORK ASSY  
ITEM -5 CHANGED FOR ITEM -4,  
ITEM -7 CHANGED FOR ITEM -5,  
ITEM -9 CHANGED FOR ITEM -6,  
ITEM -11 CHANGED FOR ITEM -7,  
ITEM -19 MCMaster-CARR #95229A430 CHANGED FOR ITEM 12  
NAS1149F0463P,  
ITEM -17 CHANGED FOR ITEM 8,  
ITEM -21 CHANGED FOR ITEM 9,  
ITEM -15 CHANGED FOR ITEM 10,  
ITEM -13 MCMaster-CARR #98381A508 CHANGED FOR ITEM 11  
McMaster#98380A507  
ASSEMBLY NOTES ADDED ON SHEET 1  
ITEM -1 DIMENSION WAS 1.125 IS 1.125 +/- 0.001, DIMENSION WAS 1.3750/1.3734 IS 1.375/1.373, ENGRAVING "MADE IN USA" / RBW6705G01451-3G AND S/N REMOVED, MATERIAL WAS 6061 CLEAR ANODIZE IS 6061/7075 RED ANODIZE, DIMENSION WAS .1874.1868 IS .1875/.1867  
ITEM -3 DIMENSION WAS 1.125 IS 1.125 +/- 0.001, MATERIAL WAS BRASS IS BRASS 360, DIMENSION WAS .510 IS .485 +/- .002, DIMENSION WAS 1.3714/1.3704 IS 1.371/1.370, DIMENSION WAS .1889/.1882 IS .1889/.1885, DIMENSION WAS .200 IS .241, 0.02 x 45° CMF 3 PL ADDED, R 0.008 MAX 3 PL ADDED  
ITEM -4 ENGRAVING REMOVED, R0.008" MAX 4 PL ADDED, MATERIAL WAS 4140 CAD PLATE IS 4140 (28-32 Rc) BLACK OXIDE, DIMENSION WAS .765 IS .88, DIMENSION WAS 6.970 IS 7.080  
ITEM -5 DIMENSION WAS .350 +/- .003 IS .350 +/- 0.002, DIMENSION WAS 1.4216/1.4200 IS 1.4200/1.4208, .03 x 45° CMF ADDED, MATERIAL WAS 1018 CAD PLATE IS 4140 (28-32 Rc) BLACK OXIDE ENGRAVING REMOVED  
ITEM -6 DIMENSION .01 x 45° CMF ADDED, R0.01 ADDED, MATERIAL WAS BRASS IS BRASS 360  
ITEM -7 MATERIAL WAS 1018 BLACK OXIDE IS A36/1018/1020 HR ZINC PLATED TYPE 2

REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA TOOL PART # <b>RBW6705G00632-3G</b> REV. A SHEET 1 OF 8 TITLE <b>T/R FLAPPING LOCKING TOOL</b> SCALE NTS COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	VM		
CHECKED	VM		
MFG. APPR.	JFS		
APPROVED	VM		
DATE	3/1/2019		

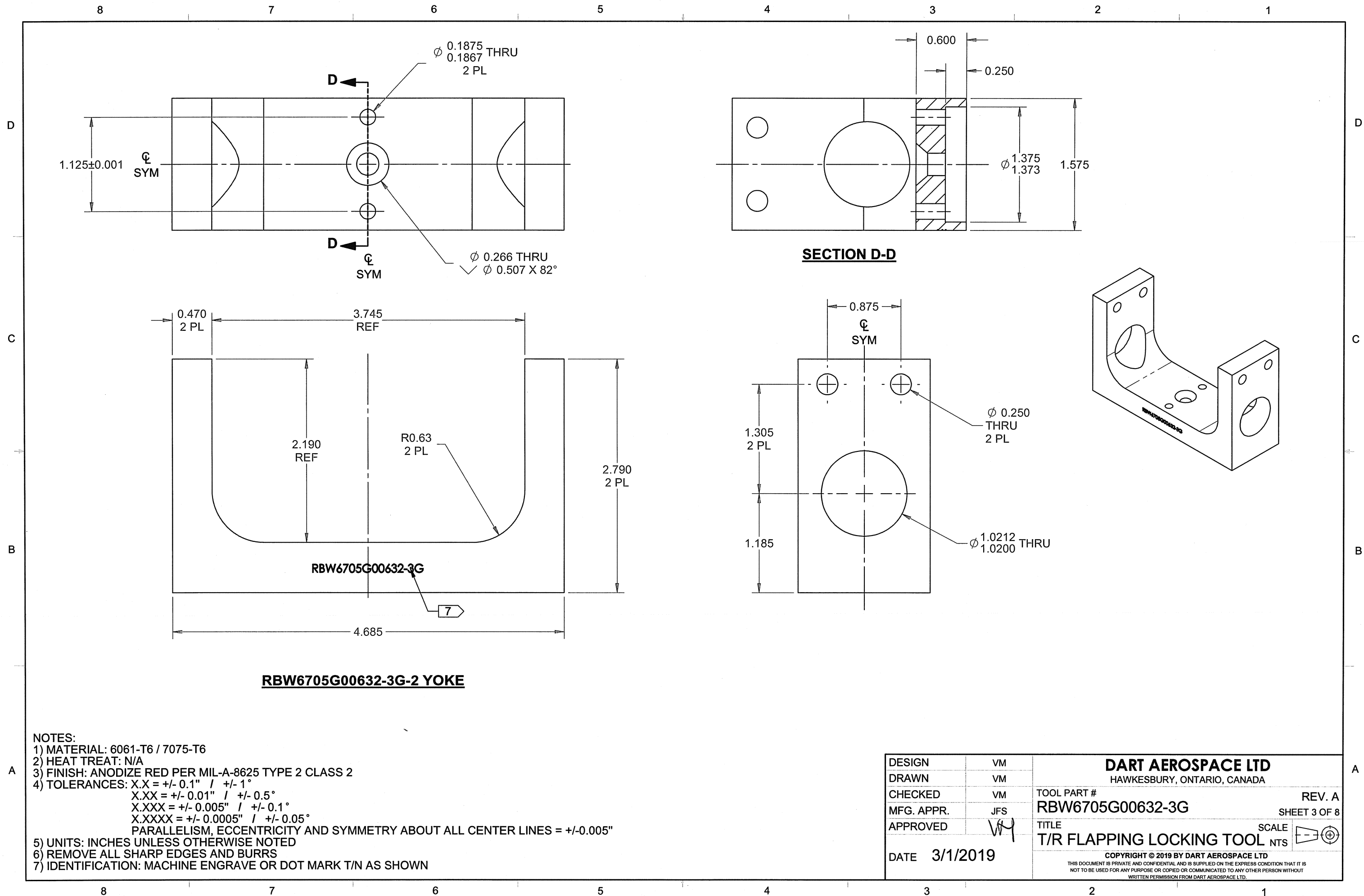
ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6705G00632-3G-2	YOKE
12	2	McMaster#98380A507 OR EQUIV	SS416 DOWEL PIN 3/16" DIA. x 5/8" LG.

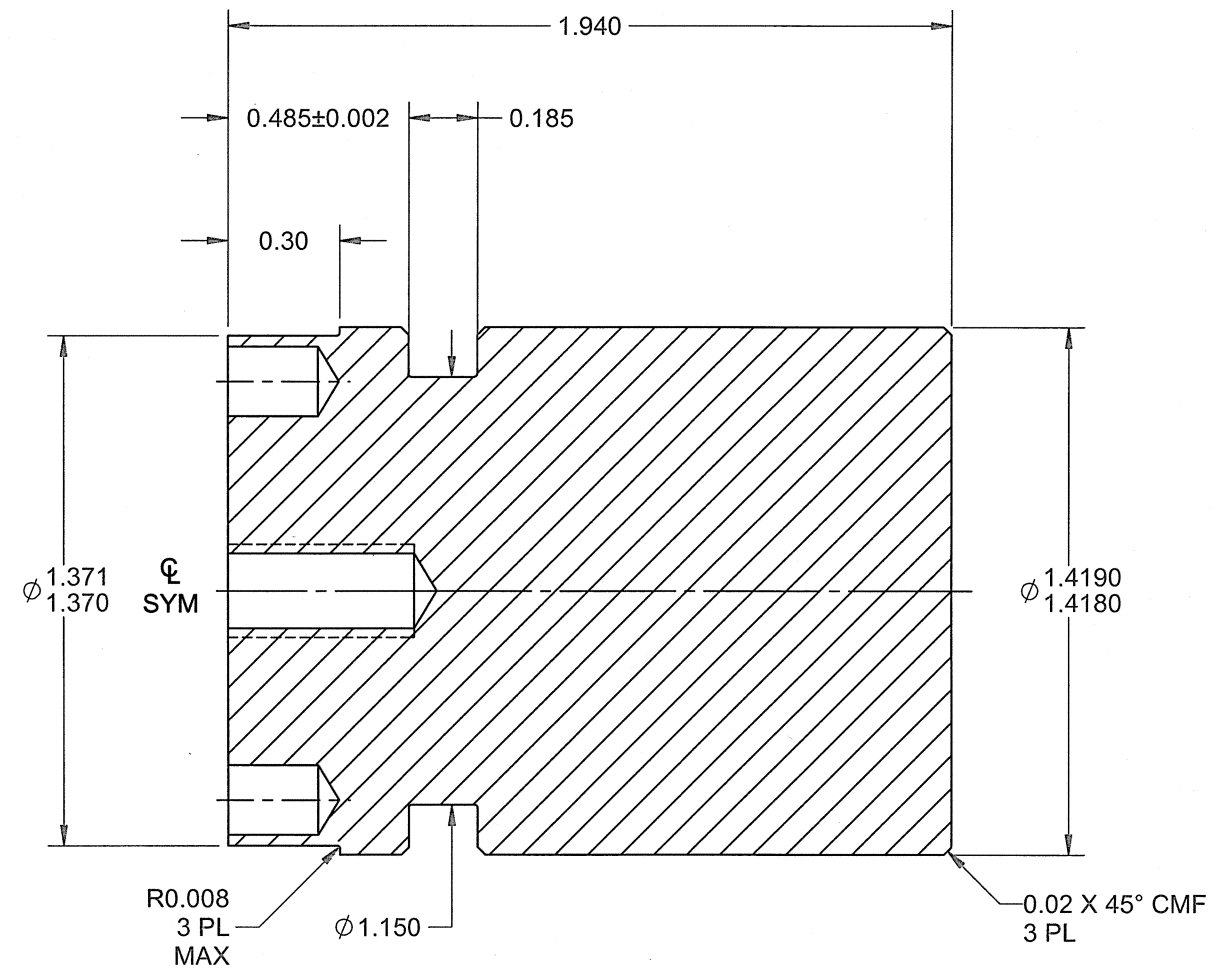
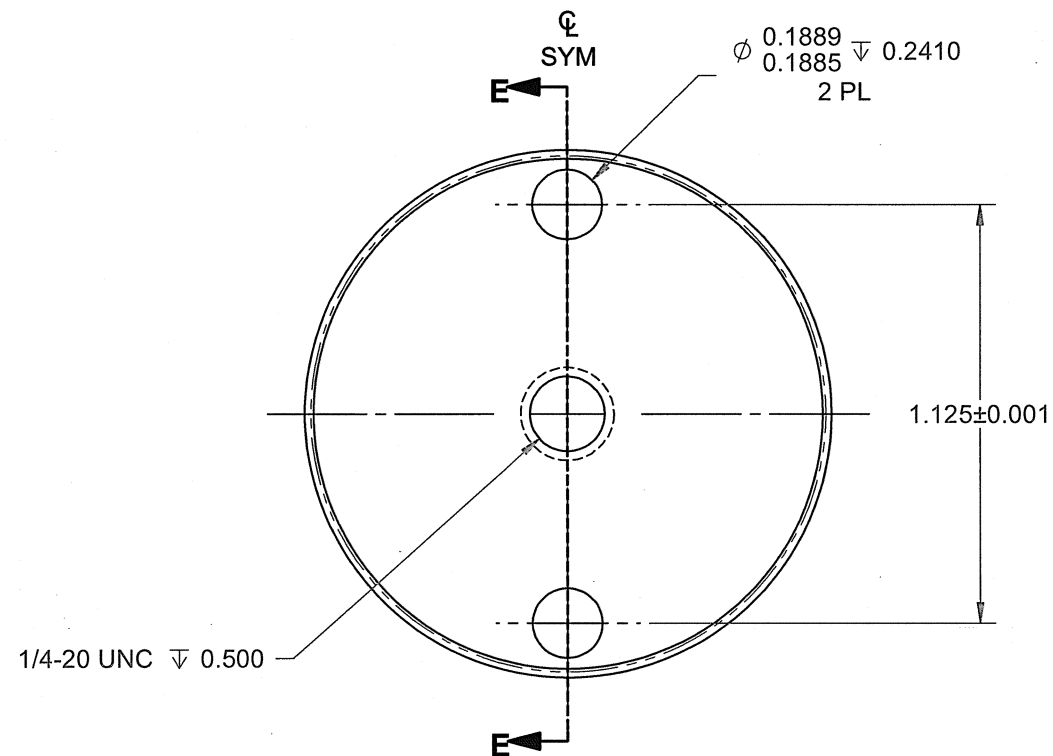


**RBW6705G00632-3G-1 YORK ASSY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) HEAT TREAT: N/A
  - 3) FINISH: N/A
  - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) IDENTIFICATION: N/A
  - 7) ASSEMBLE AS SHOWN
  - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT  
ITEMS 12 FLUSH TO SURFACE OF ITEM -2, AND REMOVE EXCESS

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFS	<b>RBW6705G00632-3G</b>	SHEET 2 OF 8
APPROVED	WJP	TITLE	SCALE
DATE 3/1/2019		<b>T/R FLAPPING LOCKING TOOL</b>	NTS
COPYRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



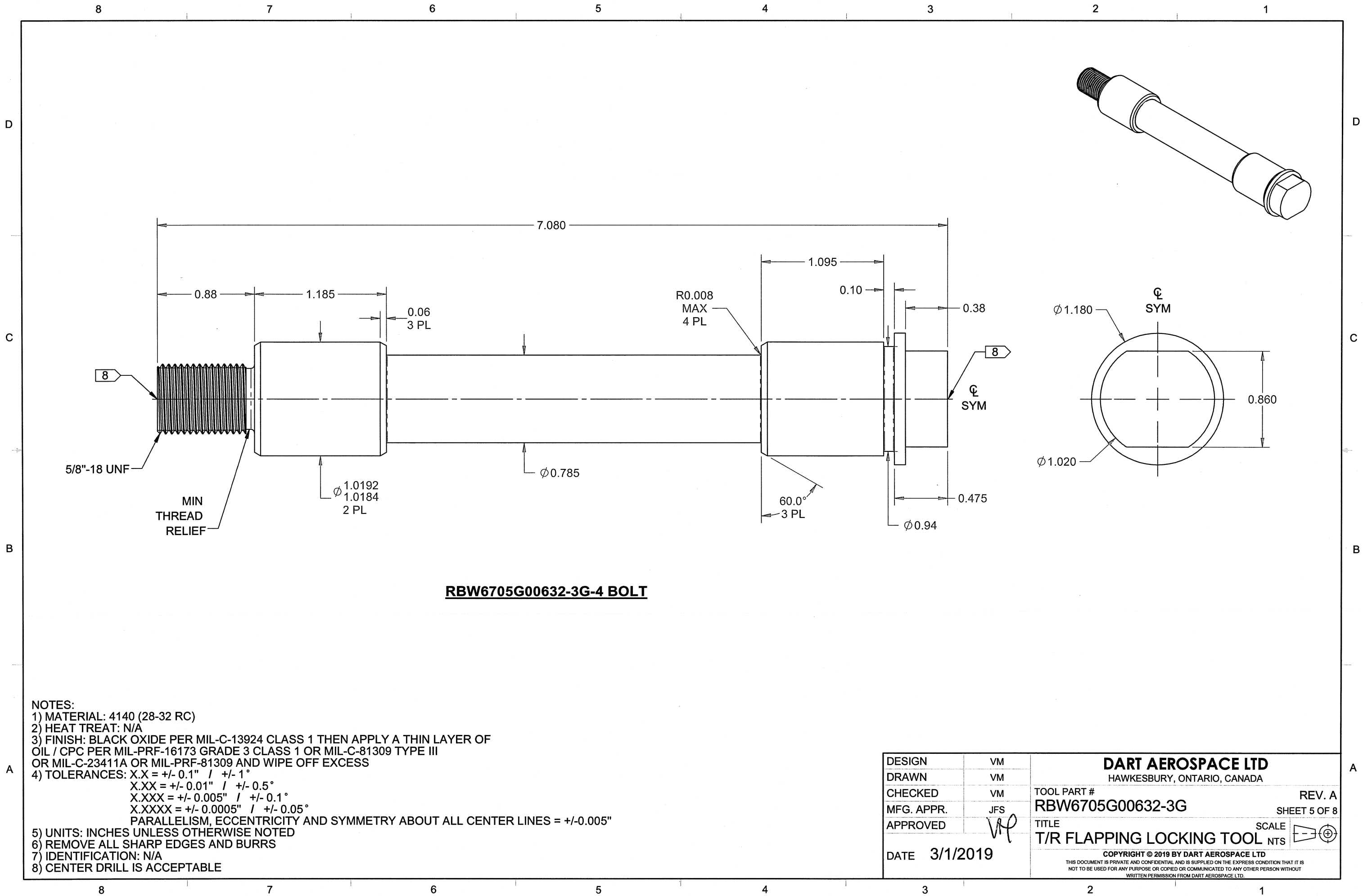


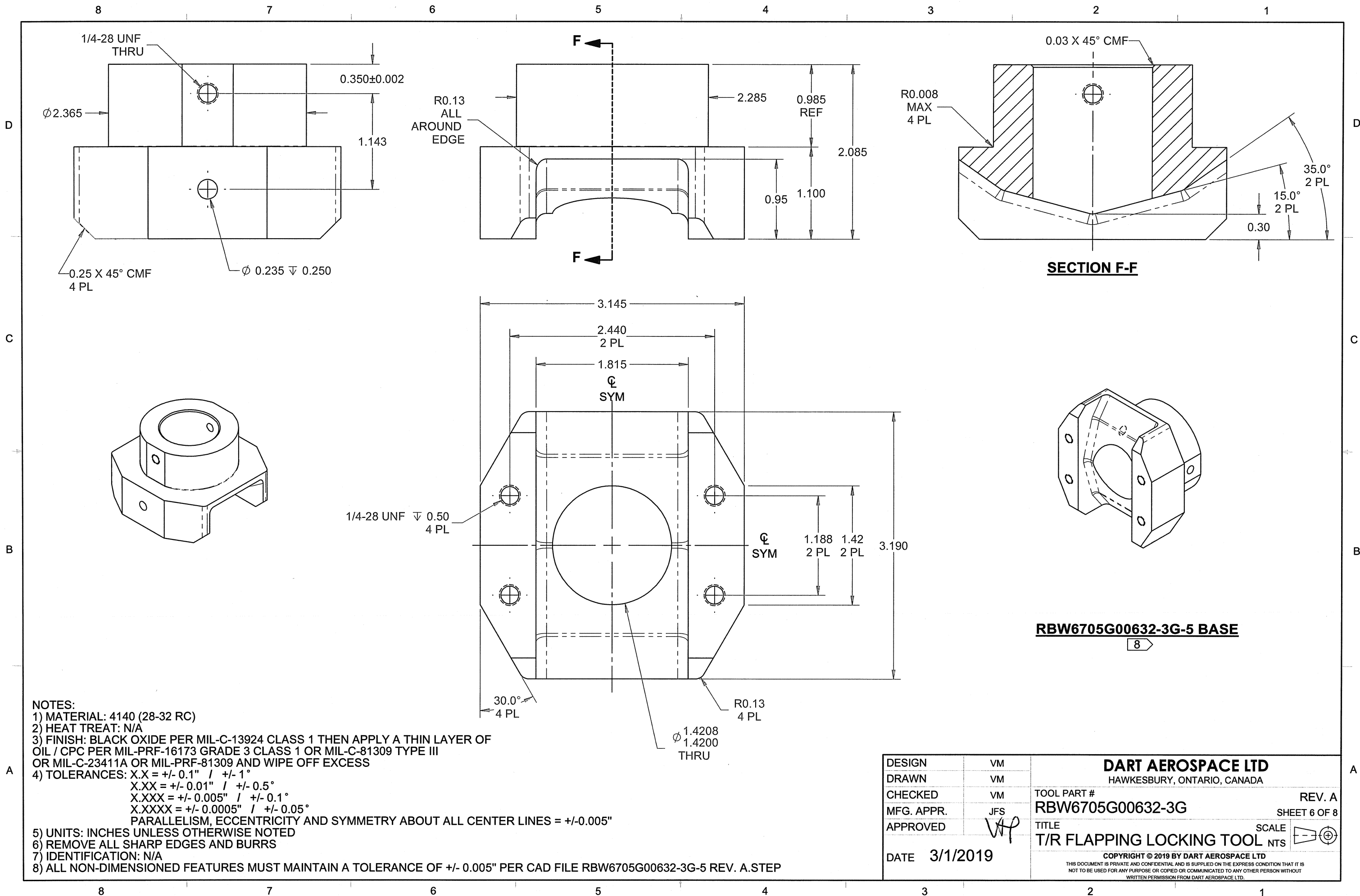
# **RBW6705G00632-3G-3 BASE**

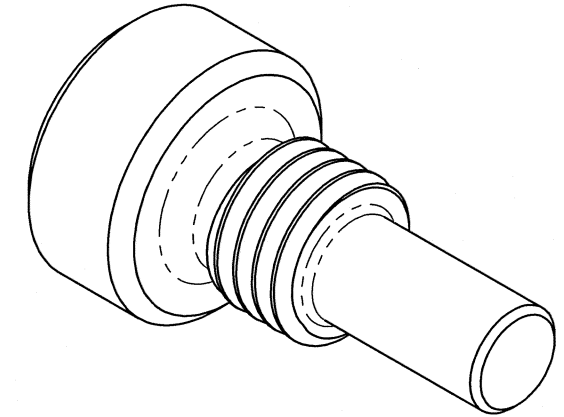
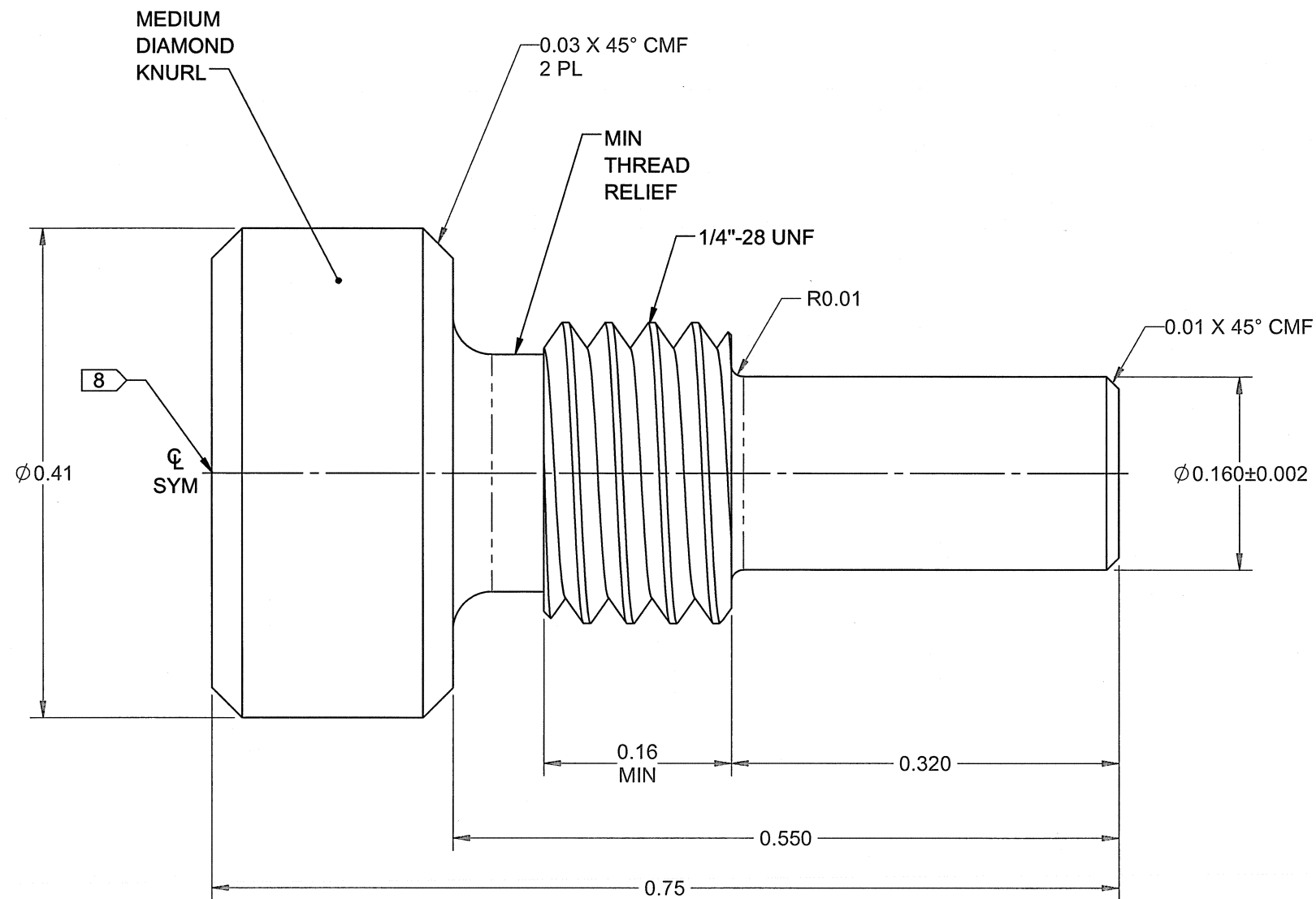
## **NOTES:**

- 1) MATERIAL: BRASS 360
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFS	RBW6705G00632-3G	SHEET 4 OF 8
APPROVED	VP	TITLE	SCALE
DATE	3/1/2019	T/R FLAPPING LOCKING TOOL	NTS
COPYRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			







**RBW6705G00632-3G-6 KNOB**

NOTES:

- 1) MATERIAL: BRASS 360
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFS	RBW6705G00632-3G	SHEET 7 OF 8
APPROVED	VM	TITLE	SCALE
DATE 3/1/2019		T/R FLAPPING LOCKING TOOL NTS	
COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8

7

6

5

4

3

2

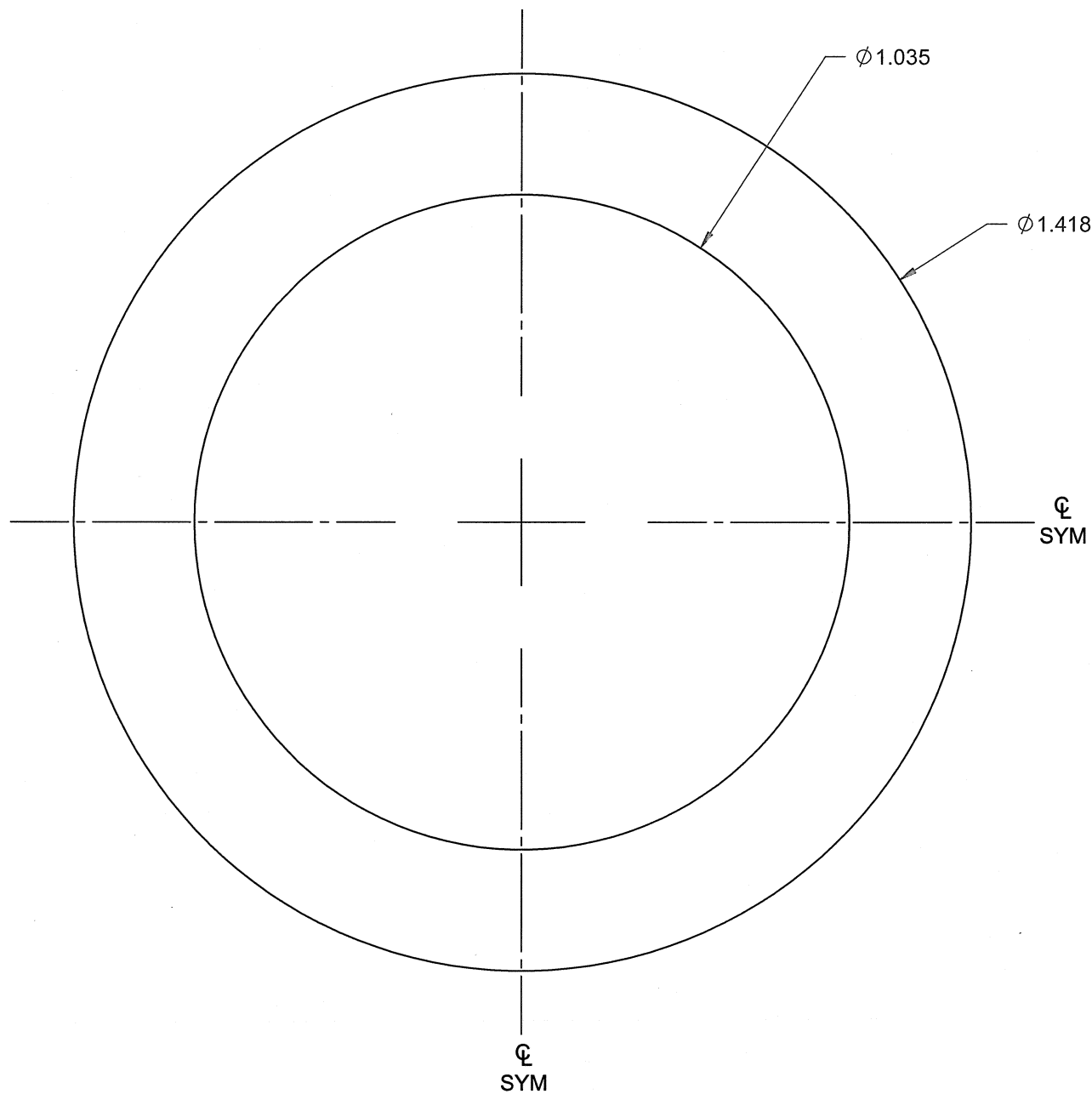
1

D

C

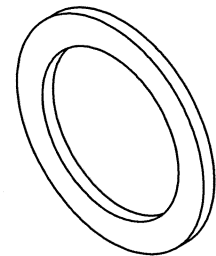
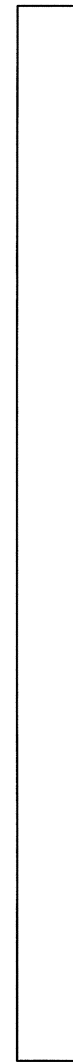
B

A

**RBW6705G00632-3G-7 WASHER****NOTES:**

- 1) MATERIAL: A36/1018/1020/1025 HR
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

0.08





D

C

B

A

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	JFS	<b>RBW6705G00632-3G</b>	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DATE <b>3/1/2019</b>		<b>T/R FLAPPING LOCKING TOOL</b>	
COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			